

Work Order ID 51097-1

July 31, 2009 2:32:03 PM



Page 1

Item ID: D3687-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: MOUNT

Start Date: 8/03/09

Start Qty: 25.00



Cust Item ID:

Required Date: 8/11/09

Req'd Qty: 25.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3687

Rev B

100

0.00



Outsource1

Memo

0.00

Outsource process - Heat Treat

Send M174B3937X4750 For heat treating
to CONDITION H-900(to become M174PHH900B3937X4750)
FTU IN EXCESS OF 190 KSI
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

CL 09/08/07 18ft.

105

0.00



Outsource5

Memo

0.00

Outsource process - Machining

Issue P/O: 10665
Machine as per Dwg D3687
Possible Supplier: Globus Precision
Conformity sheet required

CL 09/08/04 25

issue P/O
LPI P/O 10482

CL 09/09/28 (P)

Work Order ID 51097

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Page 2

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Req'd Qty: 25.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

add inspect

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

2) 502/08/25

9/9/21 (6)

9/9/28 (6)

(46) p

(910)

130

21605

Identify as per dwg & Stock Location: *118*

0.00



Packaging

Memo

0.00

Packaging

9/9/28 (6) SP

W/O: 51097

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Perm. change					
	#130	- Issue P/O for NDT testing P/O # 10482	CL	09/09/28	6		
	#140	- Review and inspect for Damage. Attach results to w/o	CU	9/9/28	6		
	#150	- inspect and ensure correct Results are attached	ML	09/09/28	6		

Part No: D 3687-1 PAR #: See NCR 09-084 Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 09/10/05

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-09-25	105	The horizontal Bolt hole is incorrect for this shipment. Parts were made to Rev. B. P/O issued Aug. 08/2009. NCR raised Aug 25/2009. RC: Globus not notified in time.	ML 09/09/26	Re-work in accordance with Eng permission to open hole to 0.261" to allow pillow block install per NCR 09-084	09/09/28 ML 09/09/26	S 09/09/28	ML 09/09/26	09-09-25

NOTE: Date & initial all entries

Work Order ID 51097

July 31, 2009 2:32:03 PM



Page 3

Item ID: D3687-1

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Setup Start



Revision ID: B

Stop



Item Name: MOUNT

Start Date: 8/03/09

Start Qty: 25.00



Cust Item ID:

Required Date: 8/11/09

Req'd Qty: 25.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/29 *[Signature]*
ME
09-09-29

Picklist Print

July 31, 2009 2:32:03 PM

Page 1

Work Order ID: 51097



Parent Item: D3687-1RevB



Parent Item Name: MOUNT

Start Date: 8/03/09

Required Date: 8/11/09

Comments:

Start Qty: 25.00

Required Qty: 25.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750		Purchased	No			100	f	3.0000	8.3333			
17-4SS Bar H900-3.937x4.750												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110875

111100

m 11 2374

3

2.9

0.1

mc 09-09-29 - 2'

D3687-1P

Purchased

No

105

Each

0.0000

25.0000

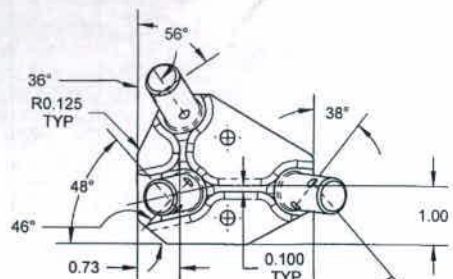


MOUNT

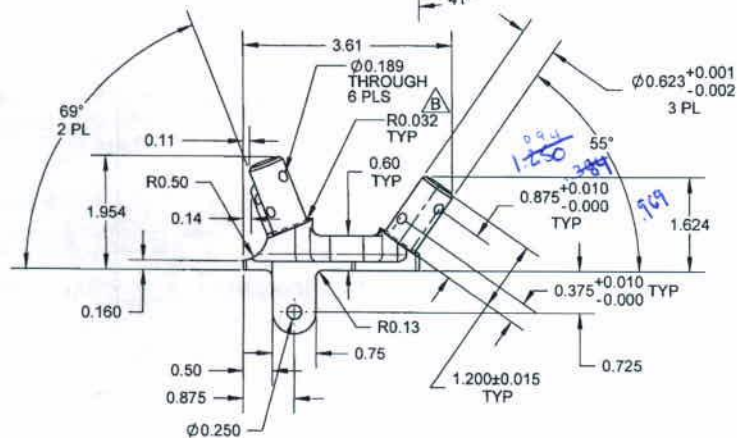
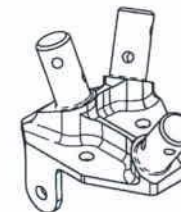


Pug/s/21 (6)

250945
25189
018
18
009
5



ulu
~~5.097~~
5.097



D3687-1 MOUNT

RELEASED
08/12/15

- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.11.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3687
TITLE MOUNT
REV. B
SHEET 1 OF 2
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

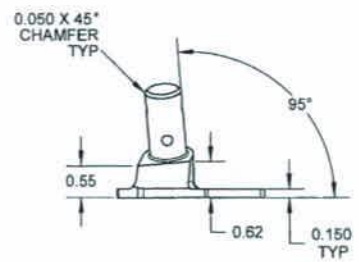
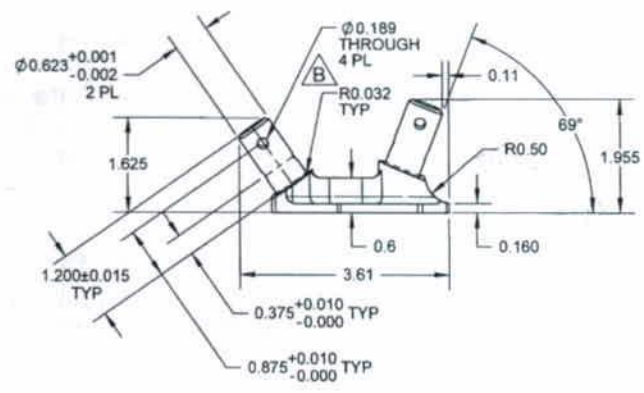
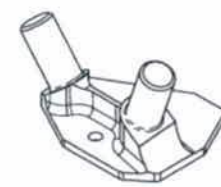
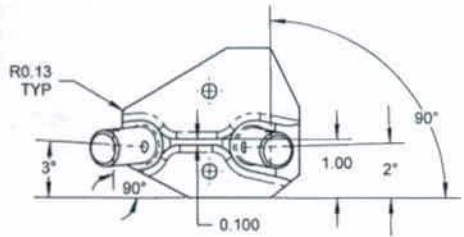
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

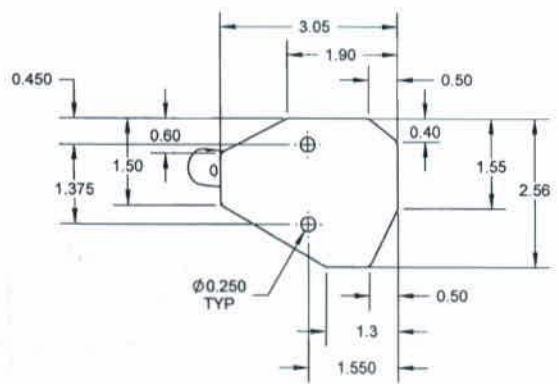
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



51097



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

D3687-3 MOUNT

RELEASED
08/12/15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3687	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**METCOR INC.**560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certification

Order	Load
149974	1

Customer 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

Shipped To:
DART AEROSPACE
1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
10126		17-4PH		

PROCESSING SPECIFICATIONS

AGE HARDEN

CONDITION H 900

SAE AMS 2759/3 REV.E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	40 - 47 HRC	28	43 - 45 HRC

Quantity	Weight	Part Number / Part Description
28	1447	BARRE RONDE 6 BARRES DE 7" + 18 BARRES DE 48" BAR 1" & 1.375" BARRE CARREE 4 BARRES DE 58" BAR 3.937 X 4.750 1 PALETTE

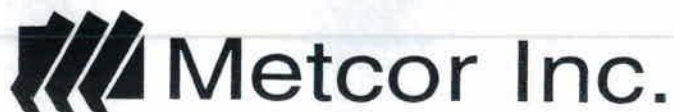
Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 AGE HARDE	900 +/-10°F	1 hrs -0 +3 MIN	air			635	08-03-09	10:15	12:30	08-03-09
4.00 HARDN INS										
5.00 FINAL INSP										08-04-09

COMMENTS

APPROVED BY:

DATE: 2009-08-05

We certify that all the information on this report is exact and in accordance with the order requirements. / Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client.



Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Tél.: (450) 473-1884
Fax Administration: (450) 491-5498
Fax Production: (450) 491-6454

Rapport d'inspection

Order	Load
149974	1

Customer 216
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

Shipped To:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
10128		17-4PH		

PROCESSING SPECIFICATIONS

AGE HARDEN
CONDITION H 900
SAE AMS 2759/3 REV E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	40 - 47 HRC	28	43 - 45 HRC

Quantity	Weight	Part Number / Part Description
28	1447	BARRE RONDE 6 BARRES DE 7" + 18 BARRES DE 48" BAR 1" & 1.375" BARRE CARREE 4 BARRES DE 58" BAR 3.937 X 4.750 1 PALETTE

COMMENTS

INSPECTOR:

[Signature]



DATE: 2009-08-04

Work Order ID 51097

July 31, 2009 2:32:03 PM



Page 1

Item ID: D3687-1

Revision ID: B

Item Name: MOUNT

Start Date: 8/03/09 Start Qty: 25.00

Required Date: 8/11/09 Req'd Qty: 25.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3687

Rev B

100

0.00



Outsource 1

Outsource process - Heat Treat

Memo

Send M174B3937X4750 For heat treating
to CONDITION H-900(to become M174P1H1900B3937X4750)
FTU IN EXCESS OF 190 KSI
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

CL 09/08/07 13ft.

105

0.00



Outsource 5

Outsource process - Machining

Memo

Issue P/O: 10665
Machine as per Dwg D3687
Possible Supplier: Globus Precision
Conformity sheet required


CL 09/08/04 25



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
9/17/2009	17714

BILL TO			SHIP TO		
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7			Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
10165	Net 30 Days	9/17/2009	FedEx	984	Globus
QTY	DESCRIPTION				
6	D3687-1P Rev. B Mount				
6	D3687-3P Rev. B Mount				
Business Number: 102122058					
WE CERTIFY THAT ITEMS LISTED HAVE BEEN MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS					
					

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO10165

Purchase Order Date 8/04/09

PO Print Date 8/04/09

Page Number 1 of 1

Order From :

VC-GLO001

GLOBUS PRECISION INC.
36 COLONNADE RD. N.
NEPEAN, ON K2E 7J6
CA

FAXED
08/04/09

Contact Name
Vendor Phone 613 226 1579
Vendor Fax 613 226 1719
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extent Pr
1	D3687-1P	MOUNT	8/19/09 Yes	New 25 6 25 Each	Purolator ground	\$400.0000	\$10.00
			Special Inst: AS PER DWG D3687 REV. B B51097				
2	D3687-3P	MOUNT	8/19/09 Yes	New 25 6 25 Each	Purolator ground	\$295.0000	\$7.37
			Special Inst: AS PER DWG D3687 REV. B B51096				
PO Total:						\$17.37	

RUSH

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 8/04/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



LIQUID PENETRANT TEST REPORT

P- 14954

ION DAT Aerospace DATE SEPT 28-2009 PAGE 1 OF 1
IS LINDA/CHATEL ACUREN JOB No. 188-09-001561 TIME AM ☒ PM ☐
IS 1270 ABELDEEN ST. POWO No. - 10482
HAWKES BURY ON. WORK LOCATION HAWKES BURY
K6H 1K7 ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
T F.P.I. ON MACHINED PARTS AND
EXAMINED CROSS TUBES.

DESCRIPTION PROCEDURE No. LT 2002 REV./DATE TECHNIQUE No. LT 2002 REV./DATE
D. STAINLESS STEEL AND MATERIAL ALUMINUM THICKNESS -
WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

DETAILS
D. ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
BRAND 2LG7 - MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
ANT 2LG7 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
ANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. OTHER LABINO
PER SKO 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE 02-8-2009
PER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

SURFACE
E CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
E TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F
TS- ☒ METRIC ☐ IMPERIAL

-W.O. 51882-CROSS TUBE	✓	-AN INSPECTION WAS DONE ON W.O. 52470 - ONE ITEM WAS REWORKED DUE TO HOLE SIZE AT BRACKET. -EXAMINATION OF THIS AREA WAS CARRIED OUT AND RESULTS AS FOLLOWS -FOUND ACCEPTABLE TO CODE <u>W.O. 09 09 28</u>
-W.O. 51881-CROSS TUBE	✓	
-W.O. 52334-CROSS TUBE	✓	
-W.O. 52335-CROSS TUBE	✓	
-W.O. 52495-MOUNTS	✓	
-W.O. 51096-MOUNTS	✓	
-W.O. 51097-MOUNTS	✓	

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Care
ing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied or intended by Acuren Group Inc.

REPRESENTATIVE Eric Doughty SIGNATURE [Signature] DTR # E-27840
DIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
PRINT: Mike Johnston NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL SNT LEVEL
CGSB REG. NO. 6066 CGSB REG. NO.